

Date: Wednesday, 4/19/2006 7:42:22 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BASKET BASE ASSEMBLY (350)
<b>Job Number</b> :	26719A		
<b>Estimate Number</b> :	10189		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D2221
<b>This Issue</b> :	4/19/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2221/D2235
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	26718A	<b>Drawing Revision</b> :	F/B1
	<b>Type</b> :	<b>Material</b> :	N/A
	LARGE FAB ASSY	<b>Due Date</b> :	4/30/2006
<b>Written By</b> :	<i>SEE COMMENT BELOW</i>		<b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>SEE ABOVE USER &amp; DATE</i>		
<b>Comment</b> :	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	<i>B26259</i>

*CPL 06-04-19*

1

2.0	D22323	Basket Hinge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	<i>B25239</i>

*CPL 06-04-26*

1

3.0	D2325	Support Gusset (350 Bask
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	<i>B25687</i>

*CPL 06-04-26*

1

4.0	D23273	Spacer Bushing
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	<i>B25823</i>

*CPL 06-04-20*

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket

*B26204*

*CPL 06.04.26*

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim

*B23544*

*CPL 06.04.26*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal

*M100722*

*CPL 06.04.25*

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall, 304/316 SS tubing

Batch: *M100704* → *336.01"*

*CPL 06.04.19*

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

*CPL 06.04.27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *LD*   Date:   *26/05/03*  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

DL 06/04/27

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/28 (1)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06-05-02 (1)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M160487

Expiry date: 11/2006

SAD 06:05:01 (1)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/05/03 (1)

Job Completion



DL 06-05-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries